

Work Order ID 59243

Friday, May 28, 2010 9:51:47 AM



Page 1

Item ID: D3697-041

Accept



Setup Start



Revision ID:

Item Name: Tube Assembly

Stop



Start Date: 5/27/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-5-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3697

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- cut at 6.00" as per dwg D3697□2- form and trim tube as per dwg D3697
using DT9003□3-deburr

FL 10-6-16 (X3)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Subaru

(X3)

120

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

FL 10-6-16 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1-weld D3697-3/-4 and D3797-1 on tube D3697-1 as per dwg D3697 using DT9003 welding jig □ 2-drill holes in tube in 6 pls as per dwg D3697								
140 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00							
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							

FL 10-6-16 X3

10.06.17 (3)

(13)

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Page 3

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Required Date: 6/4/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>M</u>	<u>10</u>	<u>06</u>	<u>17</u> (3)
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>10</u>	<u>10-6-17</u>	<u>06</u>	<u>17</u> (3)
180 Packaging Packaging	Identify as per dwg & Stock Location: <u>241A</u> Memo	0.00 0.00				<u>10</u>	<u>6-17</u>	<u>17</u>	<u>30</u> (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Item ID: D3697-041 Accept  Setup Start 
Revision ID:
Item Name: Tube Assembly Stop 
Start Date: 5/27/2010 Start Qty: 3.00  Cust Item ID:
Required Date: 6/4/2010 Req'd Qty: 3.00  Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/06/21 *[Signature]*
MF
10-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, May 28, 2010 9:51:51 AM

Page 1

Work Order ID: 59243

Parent Item: D3697-041

Parent Item Name: Tube Assembly


Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Start Date: 5/27/2010

Required Date: 6/4/2010

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3697-4		Manufactured	No			100	Each	2.0000	1	3			
													
Support Plate, RH													

B59681 X1

Location	Loc Qty	Loc Code
WA	2	
41025	2	

D3697-3		Manufactured	No			130	Each	10.0000	1	3			
													
Support Plate, LH													

Location	Loc Qty	Loc Code
ST082	10	
50386	10	

D3797-1		Manufactured	No			130	Each	4.0000	1	3			
													
Ground Plate													

Location	Loc Qty	Loc Code
ST241A	2	
46321	2	
WA	2	
40688	2	

M6061T6T0.375W.049		Purchased	No			130	f	57.5830	6	18.94737			
													
6061-T6 RD Tube .375 x.049W													

Location	Loc Qty	Loc Code
MAT014	57.583	
109000	57.583	

36'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

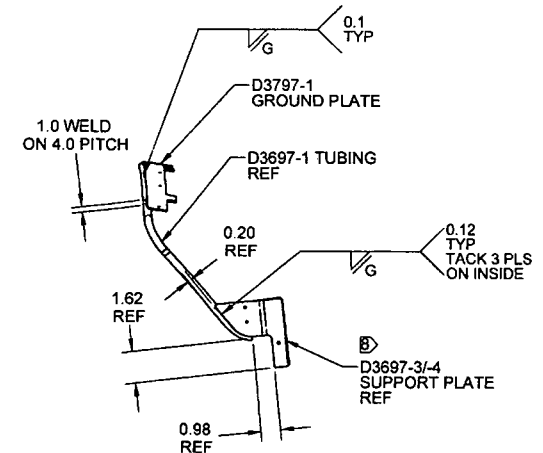
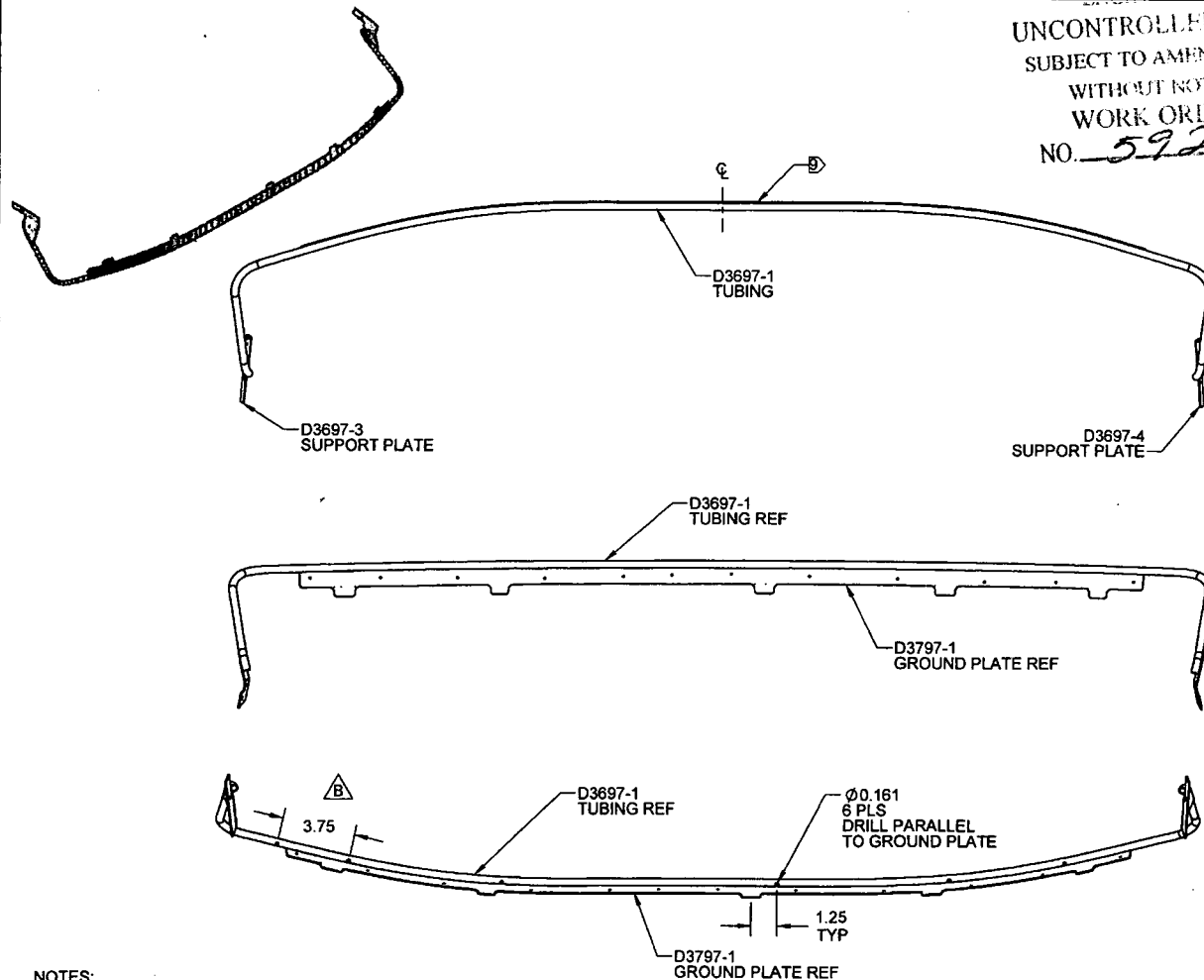
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59243



RELEASED
05-07-08

PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

B	REMOVE POWDER COAT & MASKED HATCHED AREAS SHEET 1 ZONE A,B; ADD Ø0.161 HOLE. SHEET 1 ZONE B,7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3697	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLY	NTS
DATE	08.06.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.55 lbs
- 8) LOCATE D3697-3/4 ON D3697-1 USING DT9009 WELDING JIG
- 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041 TUBE ASSEMBLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

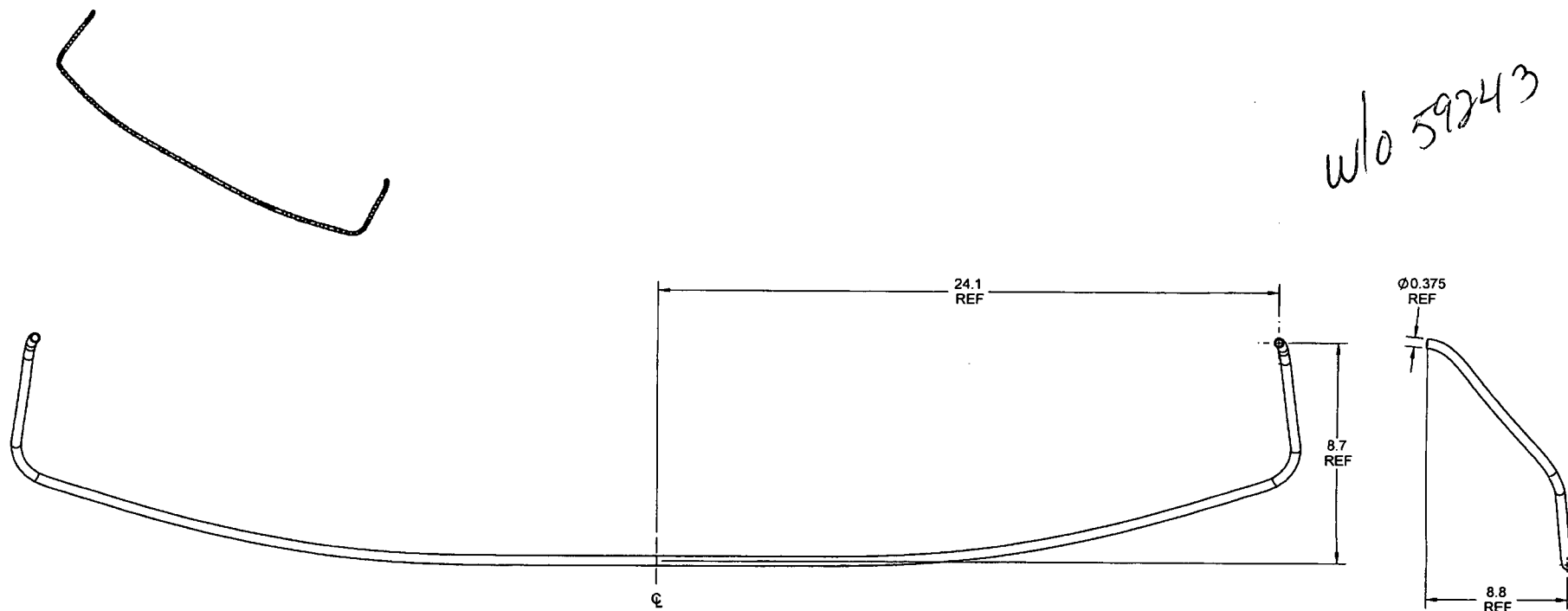
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

w/o 59243



D3697-1 TUBING

RELEASED
106-0706

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 (WW-T-700/6) ALUMINUM TUBING $\varnothing 0.375 \times 0.049$ WALL (REF. DART SPEC. M6061T6T0.375W0.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lb
- 8) FABRICATE USING TEMPLATE DT9003

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3697	REV. B
MFG. APPR.	RF	SHEET 2 OF 3	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLY	NTS
DATE	08.06.02	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

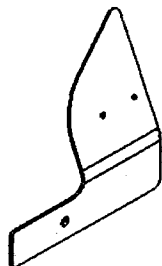
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

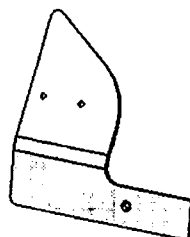
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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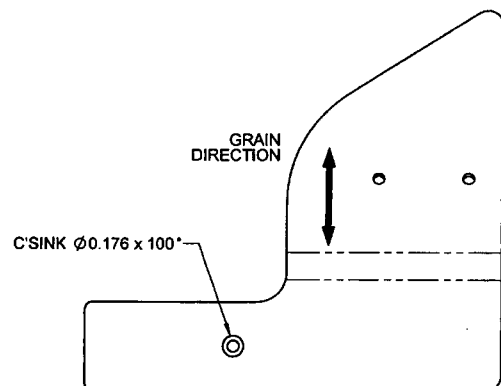
NOTE: Date & initial all entries



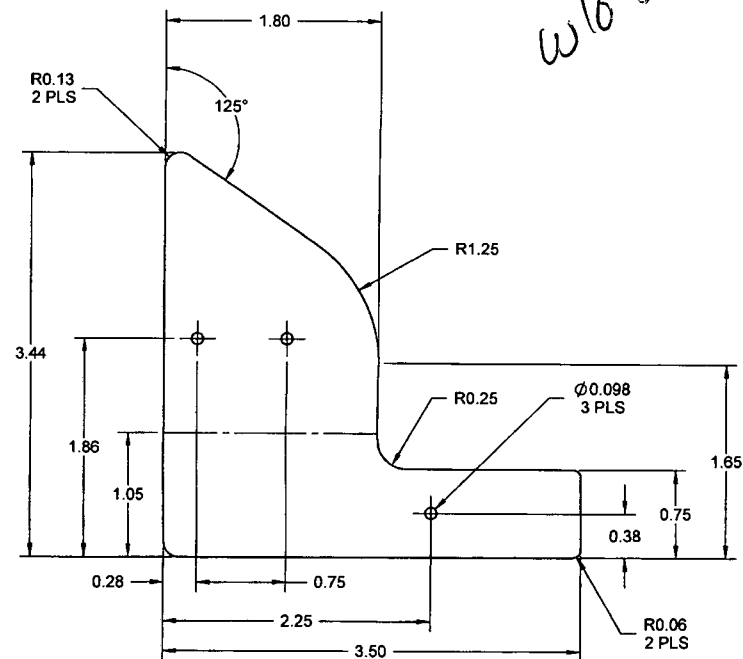
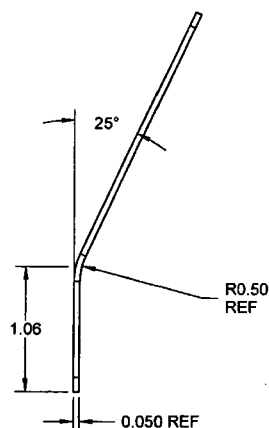
D3697-3 SUPPORT PLATE (LH SHOWN)



D3697-4 SUPPORT PLATE (RH SHOWN)



**D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
(MAKE FROM D3697-3F FLAT PATTERN)**



D3697-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RE		
CHECKED	GP	DRAWING NO. D3697	REV. B
MFG. APPR.	RE	TITLE	SHEET 3 OF 3
APPROVED	RE	TUBE ASSEMBLY	SCALE
DE APPR.	RE		NTS
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RELEASED
28 07 02/10

w/b 59247

W/O:		WORK ORDER CHANGES					
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